

pressing at least one of said sister shims against a die having a surface hardness of at least about 110-125 kg/mm<sup>2</sup> to transfer said pattern from said at least one sister shim to said die surface,

hardening the surface of said die by a process selected from ion implantation and coating the surface with diamond-like carbon, amorphous diamond coating or carbon nitride to a surface hardness of at least about 545 kg/mm<sup>2</sup>;

providing a metal article to be impressed with said holographic image, said article having a surface hardness of at least about 50 kg/mm<sup>2</sup>, and

pressing said die against a surface on said metal article to transfer said holographic image into a surface on said metal article.

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-- 27. A method of applying a holographic image to the surface of an article made of hard temper aluminum comprising:

providing a photoresist coated plate,

etching a holographic pattern in the photoresist with said pattern etched to a depth of at least about 3 microns in the photoresist,

growing a mother shim on said photoresist with said pattern in it from said photoresist,

transferring said pattern from the mother shim to multiple sister shims,

transferring said pattern from at least one of said sister shims to a die having a surface hardness of at least about 200 kg/mm<sup>2</sup>,

providing a hard temper aluminum alloy can body to be impressed with said holographic image, said can body having a surface hardness of at least about 50 kg/mm<sup>2</sup>, and

pressing said die against a surface on said can body to transfer said holographic image into a surface on said can body.

28. A method of applying a holographic image to the surface of an article made of hard temper metal comprising:

providing a photoresist coated plate,

etching a holographic pattern in the photoresist with said pattern etched to a depth of at least about 3 microns in the photoresist,